

	<h1>TECHNICAL DATA SHEET</h1>	Realease	0 17.6.2019
		Nature of mod.	First issue
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code SM23
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Cu 60 Zn Mn Sn(Si) –880/900
 AWS A 5.8: -

Chemical Composition (%)							
A.V.	Cu	Zn	Sn	Si	Mn	Ni	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.			Min. Max.
SM23	59 61	Rest	0,2 0,5	0,15 0,5	0,5 1,2		Fe – 0,1

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,01, As 0,01, Bi 0,01, Cd 0,010, Fe 0,25, Pb 0,025, Sb 0,01; total impurities (excluding Fe) 0,2

Working temperature: 900 °C
 Melting range: 880/900 °C
 Specific gravity: 8,4 g/cm³
 Tensile strength: 380-420 N/mm²
 Elongation: 30%
 Characteristics / Applications:

Special brass manganese tin alloy, suitable for gap brazing and coating of steel , cast iron, iron, nickel, nickel alloys and copper.

Heat sources:
 Acetylene torch, air-gas torch, induction and resistance heating

Flux: D54, D51A, DB, DL89,DL88, DL87 AND ECOFLUX® series

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Micro Coated Rods	spool	Powder	Paste
X	X	X	X	X		